

Date: Thursday, 17/04/2008 10:59:09 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 38653			Part Number	: D2571	
Estimate Number	: 10530			Drawing Number	: D2571 REV E	
P.O. Number	:			Project Number	: N/A	
This Issue	: 17/04/2008	S.O. No. :		Drawing Revision	: E	
Prsht Rev.	: NC			Material	:	
First Issue	: 17/04/2008	Type	MACHINED PARTS	Due Date	: 01/05/2008	Qty: 8 Um: Each
Previous Run	: 37921					
Written By	:					
Checked & Approved By	: <u>JLD 08.4.17</u>					
Comment	: Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: <u>5x31389</u> <u>3x34875</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>84</u> Double check by: <u>JL</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/04/2008 10:59:10 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 38653

Part Number: D2571

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

SL 08/05/14

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

15/05/2008

7.0 POWDER COATING

POWDER COATING



M107925



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m.1 08/05 02571

S.249 11.59

#1 316.8 F

#2 B38653 F

#3 02571 F

#4 15/05/2008 F

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



BK



08-05-15

③

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STY32

AS

08/05/15

④

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/16

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

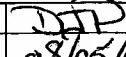
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38053
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.443	.443	.443	.443		
B	1.745	1.755		1.746	1.750	1.750	1.750		
C	3.495	3.505		3.497	3.500	3.500	3.500		
D	1.745	1.755		1.745	1.750	1.750	1.750		
E	7.990	8.010		8.008	7.998	7.999	7.999		
F	0.490	0.510		0.506	.490	.501	0.496		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		0.502	.503	.505	.505		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	.570	.579	.579		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.131	.131	.131	.132		
Q	0.115	0.135		0.135	.135	.135	.132		
R	0.240	0.260		.258	.258	.258	.258		
S	0.115	0.135		0.134	.132	.135	.131		
T	0.178	0.198		.180	.184	.184	.184		
U	2.940	2.980		2.964	2.962	2.962	2.962		
V	0.230	0.250		0.240	.245	.247	.246		
W	0.115	0.135		0.124	.123	.125	.135		
X	0.308	0.313		.312	.312	.312	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		0.365	.365	.368	0.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		0.6255	.625	.628	0.630		
AC	0.053	0.073		0.0625	.062	.062	0.0625		
AD	0.240	0.260		0.250	.250	.250	.250		
AE	1.375	1.395		1.392	1.385	1.384	1.384		
AF	0.115	0.135		0.130	.135	.135	.135		
AG	0.240	0.280		.260	.261	.265	.265		
AH	0.240	0.260		0.251	.258	.259	.257		
AI	2.000	2.020		2.007	2.002	2.003	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:		/ 87	Audited by:	
Date:	08/05/06	/ 08/05/06	Date:	08/03/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM 	

DART AEROSPACE LTD	Work Order:	38653
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5 1/2	6 1/2	7 3/8	8 1/4		
A	0.438	0.443		.443	.443	.443	.443		
B	1.745	1.755		1.750	1.750	1.748	1.749		
C	3.495	3.505		3.500	3.498	3.499	3.499		
D	1.745	1.755		1.750	1.748	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		0.510	0.506	0.505	0.505		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.505	.508	0.506	0.506		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.575	.578	0.574	0.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.132	.130	.124	.120		
Q	0.115	0.135		.135	.135	0.135	0.135		
R	0.240	0.260		.260	.248	.249	.248		
S	0.115	0.135		.132	.131	0.132	0.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.962	2.962	2.962		
V	0.230	0.250		.245	.247	0.246	0.234		
W	0.115	0.135		.133	.133	0.135	0.122		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		0.363	0.363	0.363	0.363		
AA	0.470	0.530		.520	.520	.520	.520		
AB	0.615	0.635		0.630	0.627	0.630	0.632		
AC	0.053	0.073		0.0625	0.0625	0.0625	0.0625		
AD	0.240	0.260		.250	.250	.250	0.243		
AE	1.375	1.395		1.393	1.384	1.384	1.389		
AF	0.115	0.135		.135	.135	.135	0.135		
AG	0.240	0.280		.261	.261	.261	.261		
AH	0.240	0.260		.250	.250	.246	0.243		
AI	2.000	2.020		2.003	2.003	2.003	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	8/8	Audited by:	8/1
Date:	08/05/14	Date:	08/05/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	8/1

